

Date: Friday, 20/02/2009 10:49:21 AM
User: Jean-Luc Menard








Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : LUG
Job Number : 45925	
Estimate Number : 11683	
P.O. Number :	Part Number : D2888
This Issue : 20/02/2009 S.O. No. :	Drawing Number : D2888 REV A2
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 44126	Material :
Written By : <u><i>J.F. 09.02.20</i></u>	Due Date : 27/02/2009 Qty: 10 Um: Each
Checked & Approved By :	
Comment : Est. C 00.06.22 Removed P/O for powder coat EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6B2500X03500	6061-T6 Bar 2.50 x 3.50
		
Comment: Qty.: 0.3938 f(s)/Unit Total : 3.9375 f(s) 6061-T6 Bar 2.5" x 3.5" Material: 3.5" x 2.5" bar 6061-T6 Batch <i>M110936 J.F. 09/03/03</i> (10)		
2.0	BAND SAW	BAND SAW
		
Comment: BAND SAW Cut blanks 4.20" long (Grain along 4.20") <i>J.F. 09/03/03</i> (10)		
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
		
Comment: HAAS CNC VERTICAL MACHINING #1 Machine as per folio D2888 Deburr and Tumble <i>DTP 09/02/24</i> (10)		
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <i>DTP 09/02/24</i> (10)		
5.0	QC8	SECOND CHECK
		
Comment: SECOND CHECK <i>BP 09/02/26</i> (10)		
6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
		
Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1 <i>BP 09-02-26</i> (10)		

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Seq. #:

Machine Or Operation:

Description :

7.0

POWDER COATING

POWDER COATING



m/109996



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

10:05

OVEN TEMPERATURE:

320°

FINISH TIME:

10:35

FL 09/03/02

(10)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



sl



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-03-02

(20)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 470

9/3/02

(100)

80

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/03/03

Job Completion



mf 09-03-03

DART AEROSPACE LTD		Work Order:	45925
Description: Lug		Part Number:	D2888
Inspection Dwg: D2888	Rev: A2	Page 1 of 1	

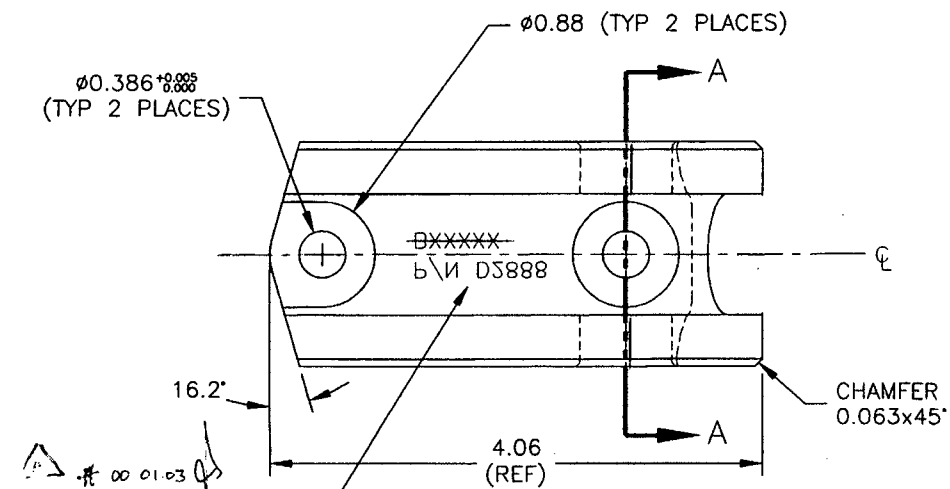
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

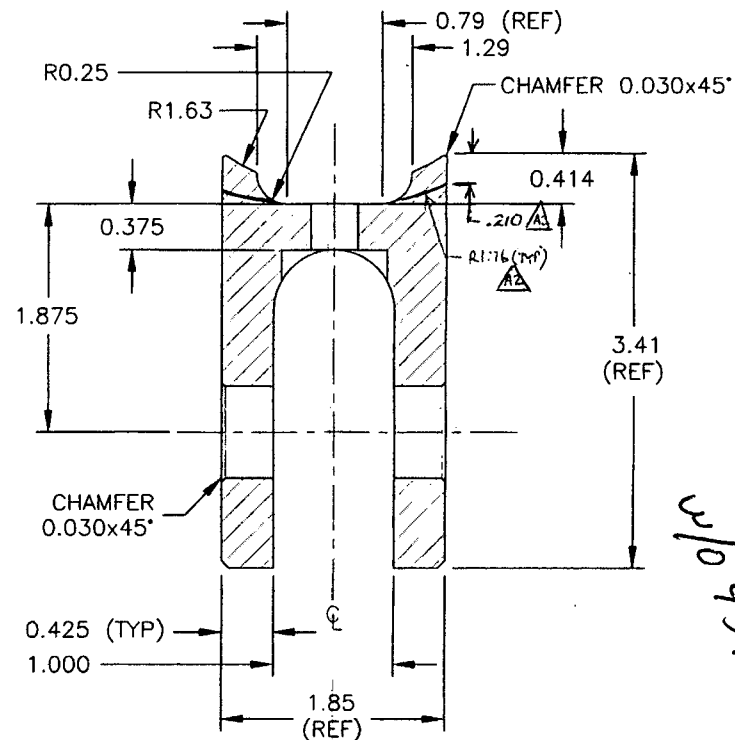
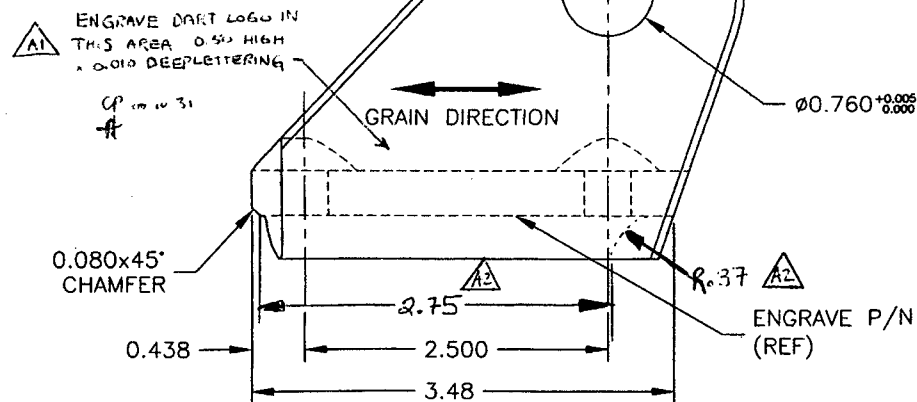
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.386	+0.005/-0.000	0.387	✓			
Ø0.88	+/-0.030	0.373	✓			
0.063 x 45°	+/-0.010	0.063 x 45°	✓			
4.06	+/-0.030	4.063	✓			
Ø0.760	+0.005/-0.000	0.761	✓			
3.48	+/-0.030	3.48	✓			
2.500	+/-0.010	2.496	✓			
2.75	+/-0.030	2.75	✓			
0.438	+/-0.010	0.431	✓			
0.080 x 45°	+/-0.010	0.08 x 45°	✓			
1.85	+/-0.030	1.844	✓			
1.000	+/-0.010	1.006	✓			
0.425	+/-0.010	0.420	✓			
0.030 x 45°	+/-0.010	0.030 x 45°	✓			
1.875	+/-0.010	1.885	✓			
0.375	+/-0.010	0.365	✓			
R0.25	+/-0.030	0.250	✓			
1.29	+/-0.030	1.288	✓			
0.414	+/-0.010	0.420	✓			
3.41	+/-0.030	3.409	✓			

Measured by:	DJP	Audited by:	BP	Prototype Approval:	N/A
Date:	09/02/24	Date:	09/02/26	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.06.04	New Issue	KJ/DD	



ENGRAVE DART PART
NUMBER AND BATCH
NUMBER IN THIS AREA
ON BOTTOM SURFACE



SECTION A-A
SCALE 1:1

RELEASED
99.07.09 DS

MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR
QQ-A-225/8)
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
BREAK UNMARKED EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

A	99.06.21	NEW ISSUE
DESIGN	DRAWN BY CP	DART DART AEROSPACE LTD WINDSOR, ONTARIO, CANADA
CHECKED	APPROVED HE	DRAWING NO. D2888
DATE 99.06.21		TITLE LUG

A2	04.04.08	Add Saddle Clearance for NCR 754
A1	05.10.31	Update Engineering